

Date: Thursday, 07/08/2008 4:21:51 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350 SKIDTUBE ASSEMBLY RH
 Job Number : 41059
 Estimate Number : 10265
 P.O. Number :
 This Issue : 07/08/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SKIDTUBES
 Previous Run : 41037
 Part Number : D350636012
 Drawing Number : D2750 ~~UNDER REVIEW~~ **PH 06.03.12 UPDATE PER DSI 9413**
 Project Number : N/A
 Drawing Revision :
 Material :
 Due Date : 30/08/2008 Qty: 1 Um: Each

Written By :
 Checked & Approved By : JLD 08.8.08
 Comment :
 Est Rev: I 02.09.25 Rearranged procedure steps KJ
 Est Rev: J 06-03-29 As per Rev D EC
 Est Rev: K 06-07.13 As per dsi9343 EC
 Est Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM
 Verified By: EC
 Est Rev: M 08-04-22 update steps 4,13 DD verified by: EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



JLD 08.8.26 8 o'clock



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-012 CHG 004 ✓

2.0 D26003BENT Extrusion Bent



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

X Qty Part Number Description Batch
 1 D2600-3-Bent Extrusion (Bent) 41122 SL 8-8-21

3.0 D2744 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

X Batch: 39242 SL 8-8-21

4.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details). Drill using drill Jig DT8150 & DT8863.

SL 8-8-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 41059

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.

4-Drill pilot holes for Detail G using DT8329

5-Open up holes for Detail B to 0.375" (4 holes per side) blade fitting location holes to 0.500" (total of 5 holes per side) as per dwg D2750. Open holes for ground handling and detail E to 0.500" (8 holes per side)

6-Drill pilot holes for wearplates as per Dwg D2750 using DT8108

****Make sure that wearplate holes are on bottom of tube****

Open 4 aft wearplate holes to 0.250". Open remaining wearplate holes to 0.297".

7-Open up holes of Detail A to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004 Fill grooves in bend left from bending as per QSI 004

A/R Aluminum Rod m107877/m108096 AE 08-08-21

10-Grind welds flush as per Dwg D2750 SL 8-8-21

5.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/08/21 (u)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/21 (u)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SL 8-8-21

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP 8-8-21

9.0

D2739

350 I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Web

Batch: 41121 SL 8-8-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 41059

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D34901

Cross Bolt Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch: 29584

RF

08/08/25

11.0

D34903

Cross Bolt Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch: 40727

RF

08/08/25

12.0

D2743

Crossbolt Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Crossbolt Spacer

Batch: 38755

RF

08/08/25

13.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open up holes of Detail E and ground handling to 0.625" (total of 8 holes per side)
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)
as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail B, E, ground handling and float holes per dwg D2750 (welding instructions on
sheet 4)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch: 108401

exp. date: 8-10-1

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 4)

SL8-8-22

W/O:		WORK ORDER CHANGES					
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 41059

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

A/R Aluminum Rod batch: *M 108096 BE 08/08/20*

9-Grind welds flush as per Dwg D2750 *JO 8-8-27*

10-Spot face ground handling holes section P-P (total of 4 places per side) as per dwg D2750

SL 8-8-28
~~*JO 8-8-27*~~

11-Deburr holes

14.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/08/29 *(42)*

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/29 *(42)*

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

M.H. 08/09/03

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

START TIME:

11:10

OVEN TEMPERATURE:

320°

FINISH TIME:

11:40

FL 08/09/03 *(1)*

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

08-09-03 *(X)*

19.0

ALS41032225

Insert



Comment: Qty.: 42.0000 Each(s)/Unit Total: 42.0000 Each(s)

Insert

Batch:

M 1004-89

M.H. 08/09/03

W/O:		WORK ORDER CHANGES					
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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 41059

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(1X)

Comment: HAND FINISHING RESOURCE #1

1-Install inserts as per dwg D2750

m-l 08/09/03

21.0

D2745

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Batch:

B36230

m-l

22.0

D353525

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch:

B39716

m-l

23.0

D353625

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch:

B40729

m-l

24.0

D35371

Wearpad



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

WEARPAD

Batch:

B38941

m-l

25.0

D37911

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

B39694 m-l

26.0

D37931

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearshoe

B40551

m-l 08/09/03

(1X)

W/O:		WORK ORDER CHANGES					
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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 41059

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

D37933

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Wearshoe

B 40552 M-H

28.0

D37941

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Gasket

B 40553 M-H

29.0

D37943

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Gasket

B 39713 M-H

30.0

D36721

Phenolic Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Phenolic Washer

B 39275 M-H

31.0

AN526C1032R10

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Screw

M 108062 M-H

32.0

AN526C1032R18

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Screw

M 108079 M-H

33.0

D36311

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
WASHER
Batch: _____

B 38139

M-H

34.0

D3488042

Blade Fitting Assembly, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Blade Fitting, RH
Batch: _____

B 38787

M-H 08/09/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 41059

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

D3492041

Plug Assembly



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: _____

B41137

M-h

36.0

D3492043

Plug Assembly



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: _____

B41090

M-h

37.0

AN3C5A

Bolt



Comment: Qty.: 34.0000 Each(s)/Unit Total : 34.0000 Each(s)

Bolt

Batch: _____

M108744

M-h

38.0

AN3C6A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: _____

M105300

M-h

39.0

AN6C44A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: _____

M109091

M-h

40.0

AN8C35A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BOLT

Batch: _____

M106896

M-h

41.0

AN960C10L

washer



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

washer

Batch: _____

M108618

M-h 08/09/03

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 41059

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

42.0

AN960C816L

WASHER



1 PA 06-08-12



Comment: Qty.: 1 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: _____

M 108928

M-h

43.0

MS210436

NUT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

NUT

Batch: _____

M 108744

M-h

44.0

MS21083C8

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

NUT

Batch: _____

M 108880

M-h

45.0

NAS1515H3L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

Batch: _____

M 108964

M-h

46.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: _____

NOT REQ'D
PA 06-08-12

47.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3"

batch: _____

M 107912

3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: _____

EXP DATE: _____

M 108801

08/10

M-h 08/09/04

(1X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 41059

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Coat all exposed fasteners with "LPS Procyon"

batch: M104251

M-1/2 08/09/04

48.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/08/04

49.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

50.0

D2741

Blade, 350 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade

Batch: B36343

51.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M107520

52.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M108880

53.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M107924

54.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: M107581

8/9/4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**
07-08-02

DESIGN <i>PH</i>	DRAWN BY <i>CB</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2750	REV. E SHEET 1 OF 5
DATE 07.05.17		TITLE 350 SKIDTUBE ASSEMBLY SCALE NTS	
REV	DATE	DESCRIPTION	
A	98.04.16	NEW ISSUE	
B	98.09.01	CHANGE MS24694-S293 TO AN8-16A	
C	98.11.18	ADD D2750-3 / D2750-4; INCORPORATE D2738 AND D2740	
D	06.01.05	ADD HOLES AND SPACERS FOR APICAL FLOATS INCORPORATE DEO 9133 / 9157	
E	07.05.17	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY(38) NAS1515H3L; REMOVE QTY(10) NAS1515H8L; REMOVE D2741, QTY(2) AN960C816; REMOVE QTY(2) MS21083C8	

Qty -041	Qty -042	Qty -043	Qty -044	Part Number	Description
X				D2750-041	SKIDTUBE ASSEMBLY, LH
	X			D2750-042	SKIDTUBE ASSEMBLY, RH
		X		D2750-043	SKIDTUBE ASSEMBLY, LH
			X	D2750-044	SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-13	WEARSHOE
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3535-35	WEARSHOE
1	1	1	1	D3536-13	GASKET
1	1	1	1	D3536-25	GASKET
1	1	1	1	D3536-35	GASKET
5	5	5	5	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
42	42	42	42	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
38	38	38	38	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN3C7A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
46	46	46	46	AN960C10L	WASHER
2	2	2	2	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER
2	2	2	2	NAS1515H8L	WASHER

PH 05-05-12
UNDER REVIEW
07-05-27-03
UPDATE
PER
DSI 9419

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41059

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DESIGN <i>PH</i>	DRAWN BY <i>CB</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2750	REV. E SHEET 2 OF 5
DATE 07.05.17		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS

GENERAL NOTES:

RELEASED
07-08-02 *[Signature]*

1. ALL DIMENSIONS ARE IN INCHES.
2. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
3. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
4. DAMAGE TOLERANCE ON BENDING:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE 3.15 ± 0.030 IN THE BENT PORTION OF THE TUBE.
5. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS C-C, D-D AND F-F.
6. WELDING TO BE DONE PER DART QSI 004.
7. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
8. FINISH:
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
9. INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4 AND 5. DRILL 'F' SIZE HOLES ($\emptyset 0.297$) FOR WEARSHOE INSERTS.
10. D3488-041 (OR D3488-042) BLADE FITTING AND AN3C5A/AN3C7A WEARSHOE BOLTS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.
11. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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DART SERVICE INSTRUCTION

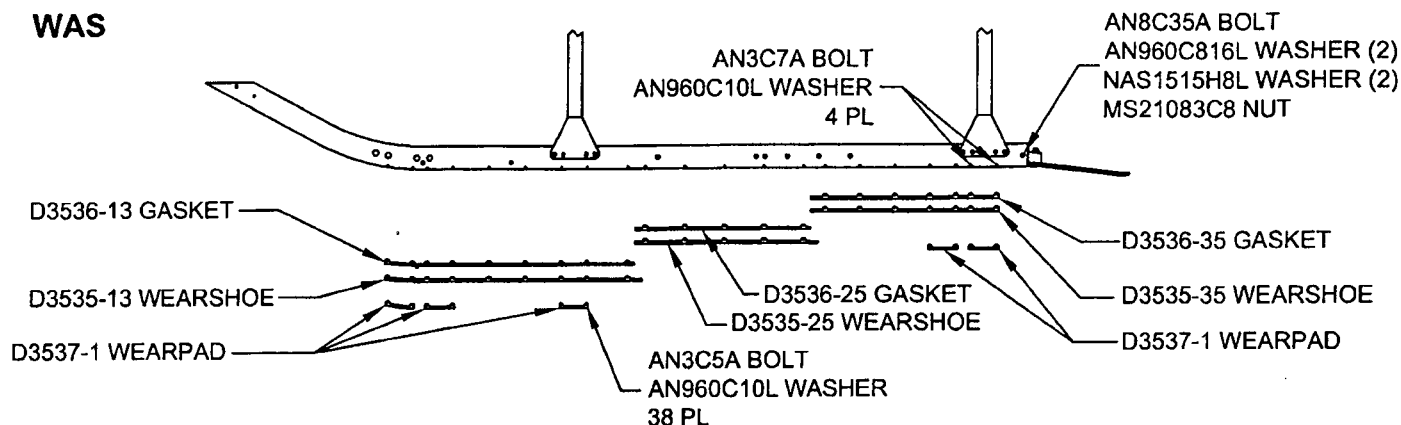
TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-636 REV E

REF FAA STC: SR00646SE

REF CANADIAN STC: SH99-7

THE WEARPLATES ON D350-636-011/-012/-013/-014 SKIDTUBES AT CHG 004 (AND LATER) HAVE BEEN MODIFIED AS SHOWN IN FIGURE 1 BELOW TO ELIMINATE THE POSSIBILITY OF INTERFERENCE BETWEEN THE WEARPLATES AND CROSSTUBE SADDLES AT INSTALLATION. THERE IS NEGLIGIBLE WEIGHT CHANGE ASSOCIATED WITH THIS MODIFICATION.

WAS



NOW

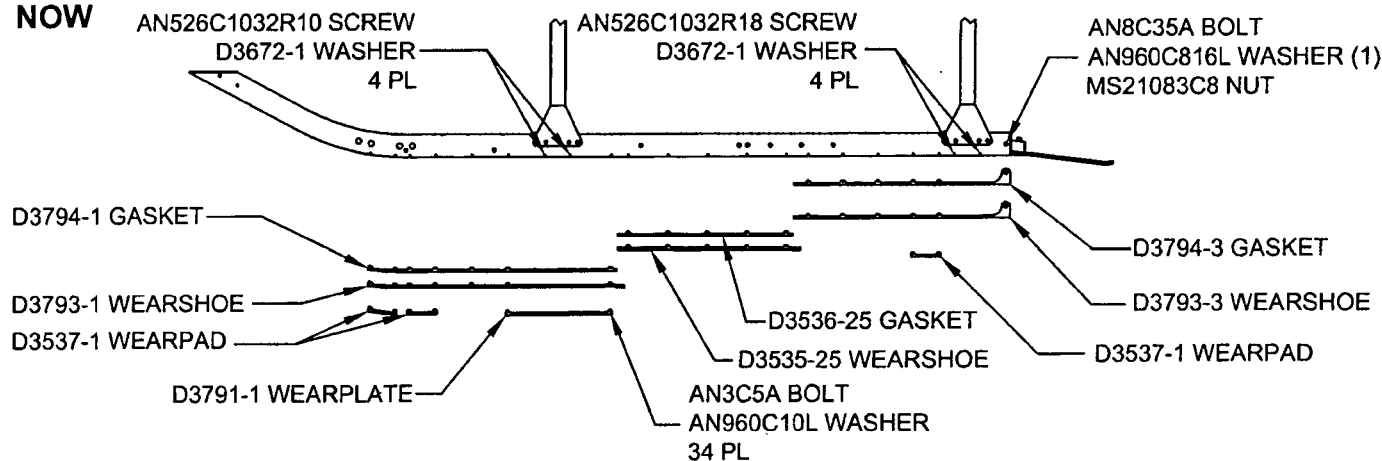


FIGURE 1 - WEARPLATE MODIFICATION

(AN526C1032RXX SCREW LOCATIONS NO LONGER USED TO MOUNT WEARSHOES)

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A	NEW ISSUE	PH	08.05.14
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	PH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9413	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE MODIFICATION	NTS
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FOR D350-636-011/-012/-013/-014 SKIDTUBES AT CHG 004, AMEND PARTS LIST OF IIN-D350-636 SECTION 5 AS FOLLOWS:

REMOVE:

Item	Qty -011	Qty -012	Qty -013	Qty -014	Part Number	Description
	X				D350-636-011	SKIDTUBE INSTALLATION, LH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
		X			D350-636-012	SKIDTUBE INSTALLATION, RH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
			X		D350-636-013	SKIDTUBE INSTALLATION, LH AIRCRUISER/ APICAL TRI-BAG FLOAT COMPATIBLE
				X	D350-636-014	SKIDTUBE INSTALLATION, RH AIRCRUISER/ APICAL TRI-BAG FLOAT COMPATIBLE
*6A	1	1	1	1	AN960C816L	WASHER
6B	2	2	2	2	NAS1515H8L	WASHER
*22	2	2	2	2	D3537-1	WEARPAD
23A	1	1	1	1	D3535-13	WEARSHOE
23B	1	1	1	1	D3536-13	GASKET
25A	1	1	1	1	D3535-35	WEARSHOE
25B	1	1	1	1	D3536-35	GASKET
*26A	4	4	4	4	AN3C5A	BOLT
*26B	4	4	4	4	AN3C7A	BOLT
*27	8	8	8	8	AN960C10L	WASHER

*SUBTRACT FROM TOTAL QUANTITY OF PARTS INDICATED IN INSTALLATION INSTRUCTIONS IIN-D350-636

ADD:

Qty -011	Qty -012	Qty -013	Qty -014	Part Number	Description
X				D350-636-011	SKIDTUBE INSTALLATION, LH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
	X			D350-636-012	SKIDTUBE INSTALLATION, RH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
		X		D350-636-013	SKIDTUBE INSTALLATION, LH AIRCRUISER/ APICAL TRI-BAG FLOAT COMPATIBLE
			X	D350-636-014	SKIDTUBE INSTALLATION, RH AIRCRUISER/ APICAL TRI-BAG FLOAT COMPATIBLE
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
8	8	8	8	D3672-1	WASHER
4	4	4	4	AN526C1032R10	SCREW
4	4	4	4	AN526C1032R18	SCREW

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TO IMPROVE THE INSTALLATION OF D350-636-011/-012/-013/-014 SKIDTUBES EQUIPPED WITH STAINLESS WEARPLATES/WEARPADS AND GASKETS (CHG 003) ONTO THE CROSSTUBES, THE FOLLOWING DSI 9413-011 WEARSHOE KIT CAN BE PROCURED FROM DART:

Qty -011	Part Number	Description
X	DSI 9413-011	WEARSHOE MODIFICATION KIT
1	D3791-1	WEARPLATE
1	D3793-1	WEARSHOE
1	D3793-3	WEARSHOE
1	D3794-1	GASKET
1	D3794-3	GASKET
8	D3672-1	WASHER
4	AN526C1032R10	SCREW
4	AN526C1032R18	SCREW

TO INSTALL THE DSI 9413-011 KIT, REMOVE THE EXISTING WEARSHOES/GASKETS UNDER THE FWD/AFT SADDLES AND INSTALL NEW WEARSHOES/GASKETS AS SHOWN IN FIGURE 1. PLUG UNUSED HOLES WITH AN526C1032RXX SCREWS AND D3672-1 WASHERS. INSTALL SCREWS WITH SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT AS SHOWN IN FIGURE 1. NOTE: SOME OF THE PREVIOUSLY INSTALLED HARDWARE IS NO LONGER REQUIRED.

THE FOLLOWING D350-636-045 REPLACEMENT WEARPLATE KIT WILL BE AVAILABLE FOR D350-636-011/-012/-013/-014 SKIDTUBES AT CHG 004 OR LATER:

Qty -011	Part Number	Description
X	D350-636-045	WEARSHOE KIT
3	D3537-1	WEARPAD
1	D3535-25	WEARSHOE
1	D3536-25	GASKET
1	D3791-1	WEARPLATE
1	D3793-1	WEARSHOE
1	D3793-3	WEARSHOE
1	D3794-1	GASKET
1	D3794-3	GASKET
34	AN3C5A	BOLT
34	AN960C10L	WASHER

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NO. 168

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 41099
Part number: D350 636 012
Description: 350 skid
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:

pass[☒] fail[]

Penetration:

pass[☒] fail[]

UNACCEPTABLE

Cracks:

pass[☒] fail[]

Undercut:

pass[☒] fail[]

Pin holes:

pass[☒] fail[]

Overlap (cold lap)

pass[☒] fail[]

Porosity (surface):

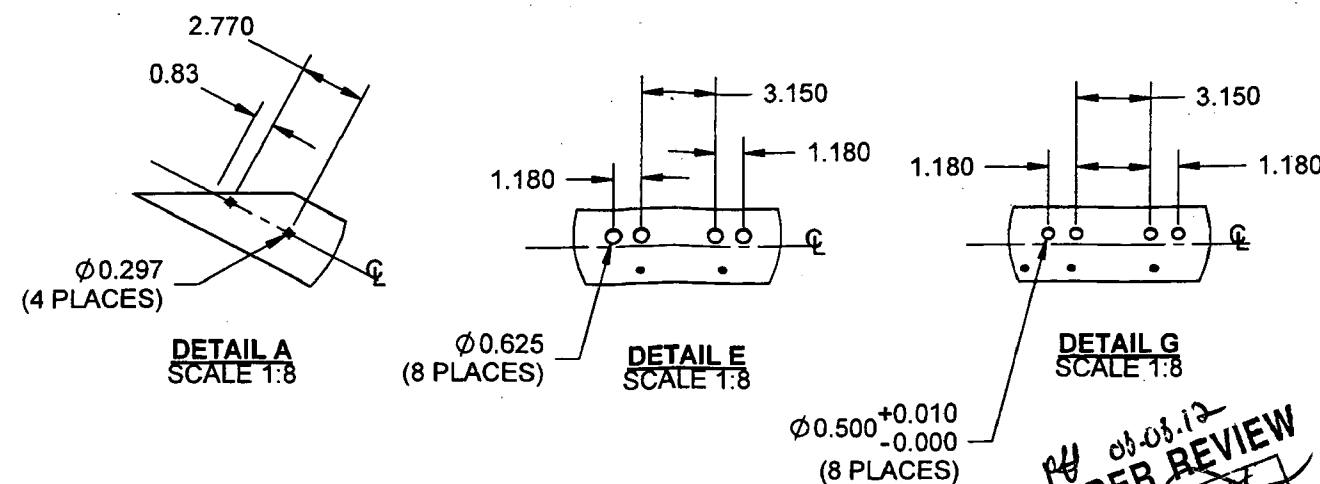
pass[☒] fail[]

Coloration:

pass[☒] fail[]

Qualifier Pet. Durl. Date of Test Coupon 08-08-21
Welder Barclay Elliott Date of Test Coupon 08-08-21

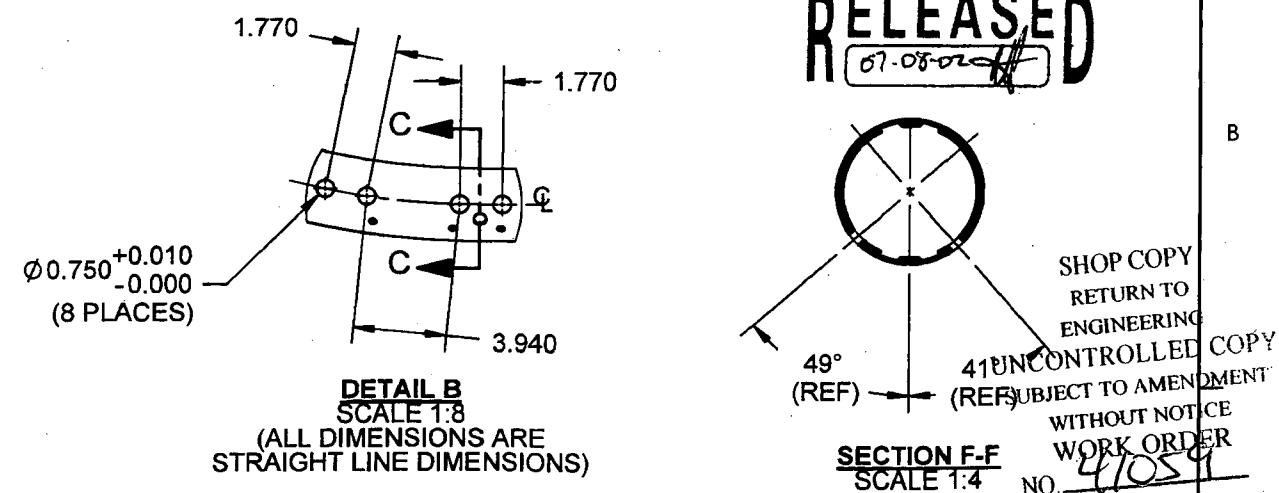
The above named individual is qualified in accordance with AWS D17.1.2001 to weld



Technical drawings of two sections of a circular component. Section C-C shows a circular cross-section with a central point and a radial line at an angle of 23.5 degrees. Section D-D shows a similar circular cross-section with a radial line at an angle of 17 degrees. Both sections are labeled with their respective section names and scales.

SECTION C-C
SCALE 1:4

SECTION D-D
SCALE 1:4



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DATE 07.05.17		TITLE 350 SKIDTUBE ASSEMBLY SCALE 1:20	

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D

C

B

A

D

C

B

A

**D2750-043 ASSEMBLY (SHOWN)
D2750-044 ASSEMBLY (OPPOSITE)**

BOND D2739 WEB INTO D2750-3 (OR D2750-4)
OUTER TUBE WITH NON-STRUCTURAL
SIKAFLEX-241 ADHESIVE PER DART QSI 015.
NOTE: ENSURE THAT HOLES LINE UP.

INSTALL ALS4-1032-225
INSERTS (4 PLACES)
AFTER FINISH

D2750-3 (LH) OR
D2750-4 (RH)

INSTALL ALS4-1032-225
WEARSHOE INSERTS (38 PLACES)
AFTER FINISH

BLACK ANTI-SKID

2.0
(TYP)

1.78 (REF)
(TO D2739 WEB)

D3488-041
(OR D3488-042)

NO INSERT

WELDED SPACER
NOT REQUIRED

AN3C7A BOLT (REF)

D3535-25
D3536-25

D3535-35
D3536-35

D3537-1

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01.06.2012
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PER
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INSTALL:
AN3C6A BOLT (1)
AN960C10L WASHER (1)
NAS1515H3L WASHER (1)
(4 PLACES)

SECTION J-J
SCALE 1:5

INSTALL AT AFTMOST
D3537-1 WEARPAD:
AN3C7A BOLTS (1)
AN960C10L WASHER (1)
(4 PLACES)

SECTION N-N
SCALE 1:5

INSTALL:
AN3C5A BOLT (1)
AN960C10L WASHER (1)
(38 PLACES)

D2743 SPACER (REF)

SECTION M-M
SCALE 1:5

WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 x 45°
2) INSERT D2743 SPACER
3) WELD INTO PLACE
4) GRIND WELD FLUSH
5) DRILL OUT SPACER TO $\phi 0.484$
6) SPOT FACE $\phi 0.750$ (SECTION P-P ONLY)

SECTION P-P
SCALE 1:5

INSTALL:
AN6C44A BOLT (1)
D2745 BUSHING (2)
D3631-1 WASHER (2)
MS21043-6 NUT (1)
(4 PLACES)

SECTION Q-Q
SCALE 1:5

INSTALL:
AN8C35A BOLT (1)
AN960C816L WASHER (2)
NAS1515H8L WASHER (2)
MS21083C8 NUT (1)

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DETAIL H
SCALE 1:5

SECTION T-T
(FOR $\phi 0.500$ HOLES ONLY)
SCALE 1:5

WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 x 45°
2) INSERT D3490-5 SPACER (4 PLACES) INTO
 $\phi 0.313$ HOLES OR INSERT D3490-1 SPACER
(4 PLACES) INTO $\phi 0.500$ HOLES
3) WELD INTO PLACE
4) GRIND WELD FLUSH
5) INSERT D3492-045 PLUG ASSEMBLY (8 PLACES)
INTO D3490-5 SPACER OR INSERT D3492-043
PLUG ASSEMBLY (8 PLACES) INTO D3490-1 SPACER
ON BOTH ENDS AFTER FINISH

SECTION U-U
(FOR $\phi 0.313$ HOLES ONLY)
SCALE 1:5

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